



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-1
Job Sheet 173622



Part No: RBST1009-1

Job Qty: 10 ea

Part Name: Roller Fixture



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/13/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	10 pcs		3/14/18	0.00	2.50	MORI SL-154		
120	QC	10 pcs		3/14/18	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs		3/14/18	0.00	0.00	QC8 Machining-4		
132	Outsource	10 pcs		3/14/18	0.00	0.00	Outsource1		
140	Outsource	10 pcs		3/14/18	0.00	0.00	Outsource13		
150	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging2		
160	QC	10 pcs		3/14/18	0.00	0.00	QC6		
210	Packaging	10 pcs		3/14/18	0.00	0.00	Packaging3-1		
220	QC21-SA	10 Ea		3/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB 936 FOLIO REV: _____ DWG REV: 9.00 2-Deburr 3- Tap
Descriptions: by hand #8-32 thread

120 - 1-Engrave P/N using Marktronic engraver as per DWG.

132 - 1--Issue P/O to Metcore ; P/O 039529 RC55-60 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech

140 - -Issue P/O to Groupe Altech: P/O 039615 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.625	Tool Steel Round Bar 1.625 dia.	1.6250 ft (.1625 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-R1.625	2	3	0

Part S

Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S058610



Part: RBST1009-1

Job No: 173622

Serial No/Batch: S058610

Revision: 7

Inspector:

28 3/4

6.0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

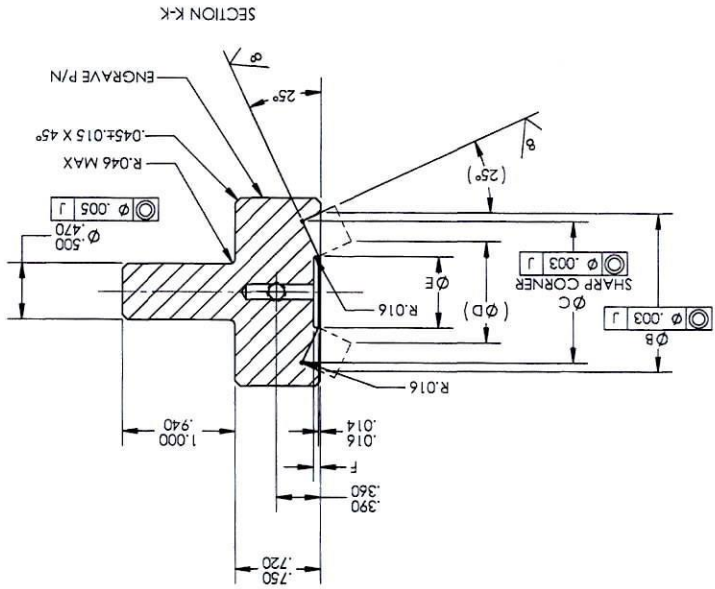
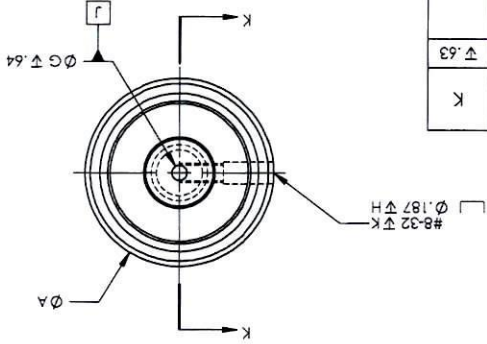
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14 07 31	New Issue	K.J	

TOOL NUMBER	Ø A	Ø B	Ø C	Ø D	Ø E	Ø F	Ø G	H	K
RBST1000	1.250	.993	.846	.500	.238			± .25	± .63
RBST1001		1.056	.909	.563	.301				
RBST1002		1.087	.940	.594	.332				
RBST1003	1.375	1.118	.971	.625	.363			± .31	± .69
RBST1004		1.153	1.006	.660	.398				
RBST1005		1.205	1.058	.712	.450				
RBST1007	1.625	1.299	1.152	.806	.544			± .43	± .81
RBST1008		1.330	1.183	.837	.575				
RBST1009		1.369	1.222	.876	.614				
RBST1010		1.393	1.246	.900	.638				
RBST1011	1.875	1.463	1.316	.970	.708				
RBST1012		1.518	1.371	1.025	.763			± .56	± .94
RBST1013		1.556	1.409	1.063	.801				
RBST1014		1.580	1.433	1.087	.825				
RBST1015		1.744	1.597	1.251	.989			± .68	± 1.06
RBST1016	2.125	1.806	1.659	1.313	1.051				
RBST1017		1.931	1.784	1.438	1.176				
RBST1018	2.375	1.994	1.847	1.501	1.239			± .81	± 1.19
RBST1019		2.119	1.972	1.626	1.364				
RBST1020	2.875	2.494	2.347	2.001	1.739			± 1.06	± 1.44





Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039615**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039615
PO Date: 4/16/18
Due Date: 4/20/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173622	RBST1009-1	Roller Fixture -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/20/18	10 pcs	0 pcs ✓ 10x	10 pcs	\$12.00/pcs AT 19/6/18	\$120.00
Grand Total:										\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/18/18 11:27 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008455 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
24-Apr-2018		Aman		039615				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBST1009-1 Rev.	RBST1009-1 01 -OXIDE BLACK PER MIL-C-13924C CLASS 1	OXIDE-BLACK CH	10	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.